5/46

DART AEROSPACE LTD	Work Order:	24678	
Description: Bracket Assembly	Part Number: D3121-043		
·		D3121-044	
Dwg: D3121 Rev. C2 page 1, 3, 5	Qty:	∠ Kits	
D3121-043 replaces Premier P/N B30-23000-37			
D3121-044 replaces Premier P/N B30-23000-38		Page 1 of 1	

Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveler	del	05.10.26	4
2	MV	Dwg not required Cut (1) blank per D3121-13 & (1) blank per D3121-14 Cut blanks (1.00" x 2.00") x 3.250" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B1.000x02.000) Batch: M4773	J-L		4
3	MV	Machine D3121-13 as per Folio FA329 and Dwg D3121		05-11-14	U
4	QC2	Inspect parts as they come off the CNC machine	J.L J.L	05.11.17	4
5	MV	Machine D3121-14 as per Folio FA329 and Dwg D3121	71	05.11.18	4
6	QC2	Inspect parts as they come off the CNC machine		05.11.18	4
7	MV	Deburr Break all sharp edges 0.005 to 0.015	7.1	05/11/8	4
8	MV	Scribe batch number to D3121-13 & D3121-14 at the back face.		05.11.18	8
9	QC5	Second check D3121-13 and D3121-14	Ting	08/1/18	B
10	GA	Assemble D3121-043 as per Dwg D3121 Pick: Qty Part Number Description Batch 2 D3121-21 Bolt G244758 2 D3121-241 Bearing Assembly R24777 Identify as D3121-043	136-	65.11.7c	Ч
11	GÁ	Assemble D3121-044 as per Dwg D3121 Pick: Qty Part Number Description Batch 2 D3121-21 Bolt 37244753 2 D3121-241 Bearing Assembly 324777	B6-		
12	QC5	Identify as D3121-044 Inspect work to Step 10 & 11	36	05:11.70	442
13	ST	Identify and Stock in Spacedoor cell D3121-043 Qty	liv .	5/11/21	4+4
14	AC	Parts to Stock and Prorate Cost to parts per Step 13 Cost / part:			7.7
15	DC	Close W/O Inspect Level 21	0	05/11/23	8

Rev	Date	Change	Revised By	Approved
Α	02.05.21	New issue	NG	1
В	03.05.02	Reformat	KJ/RF	1//
С	05.01.27	Revised Steps 10-11	KJ/JLM	611

DELEASET

ALSO J